

Ship 14/04

Work Order ID 68232

Friday, April 08, 2011 3:02:35 PM



Item ID: D3953-11

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Spacer

Stop



Start Date: 4/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 20.00



Customer:

Ship 14/4

Reference:

Approvals:

Process Plan: MC

Date: 11-04-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER EOMO FA856 & DWG

FOLIO REV: 14

DWG REV: 1

DEBURR

11.4.12 20

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

11.4.12 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

CML 11/04/12

20

0

Quality Control

130

Identify as per dwg & Stock Location: 96

0.00



Packaging

Memo

0.00

Packaging

11/4/12 SF 20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13

11-09-13
00

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Picklist Print

Friday, April 08, 2011 3:02:32 PM

Page 1

Work Order ID: 68232



Parent Item: D3953-11



Parent Item Name: Gas Spring Spacer

Start Date: 4/8/2011


Required Date: 4/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNRN0.750  Delrin Round Bar 0.75"		Purchased	No			100	f	118.0000	0.06	1.263158			



11.4.12

Location

Loc Qty

Loc Code

MAT055

118

115472

33

116183

5

117273

56

117322

24

1.25

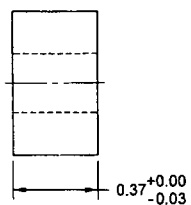
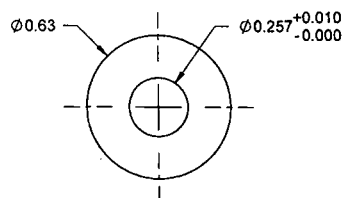
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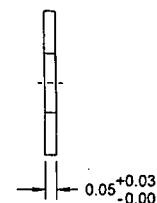
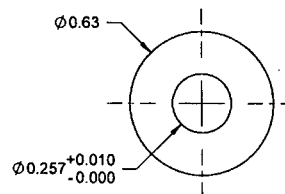
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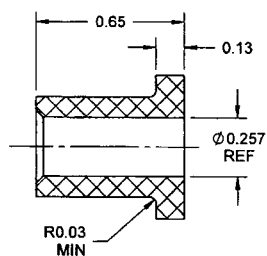
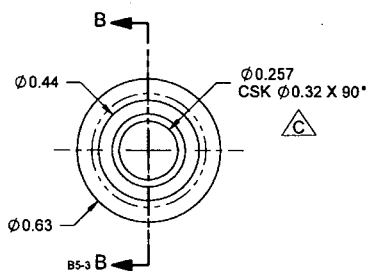
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

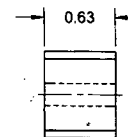
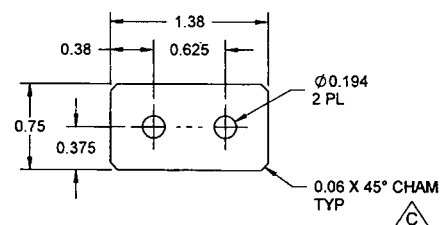


D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	
DATE	10.01.29	NTS	
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DART AEROSPACE LTD		Work Order:	68232
Description: Gas Spring Spacer		Part Number:	D3953-11
Inspection Dwg: D3953	Rev: C		Page 1 of 1

☒ **First Article** ☐ **Prototype**

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